

18

Date: Monday, 02/03/2009 9:04:00 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT/CO-PILOT STEP, RH (FOLDING)
 Job Number : 46122
 Estimate Number : 10824
 P.O. Number :
 This Issue : 02/03/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL /MED FAB
 Previous Run : 46120
 Part Number : D412630032
 Drawing Number : IIN D412-630
 Project Number : N/A
 Drawing Revision : *km* *09/03/02*
 Material :
 Due Date : 27/03/2009 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : *JLD 09.03.02*
 Comment : EST. REV. A 05.11.21 NEW ISSUE EC
 EST. REV. B 05.12.19 updated pick list EC
 EST. REV. C 07.11.12 ecn 1019, nochg EC
 verifiedby:DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



HJ for JLD 09/03/16



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CH001

CH001 5/3/23

2.0 D3463042 Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3463-042 Step weldment

B46154

EP 09/03/23

3.0 D3443043 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3443-043 Strut ass'y

B46129 (3x)

B46130 (1x)

EP 09/03/23

4.0 D3443041 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
 1 D3443-041 Strut ass'y

B46127

EP 09/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34439

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3443-9	Pin	<u>B46131</u>

SS 09/03/17 x4

6.0

AN4CH3

SS Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN4CH3	BOLT	<u>M110605</u>
A/R MS20995c41e Lockwire			<u>M101537</u>

SS 09/03/17 x4

7.0

D34547

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-7	Bushing	<u>B44589</u>

SS 09/03/17 x4

8.0

AN3104

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	AN310-4	Nut	<u>M167139x1</u>

M111060 x7

SS 09/03/17 x4

9.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-227	COTTER PIN	<u>M109174</u>

SS 09/03/17 x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 46122

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3455-1	Spacer	

B44602

SS 09/03/17 (X4)

11.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3465-1	Washer	

416092

SS 09/03/17 (X4)

12.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN310-7	Nut	

M103286

SS 09/03/17 (X4)

13.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS24665-302	COTTER PIN	

M106703

SS 09/03/17 (X4)

14.0

AN4C14

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	AN4C14	BOLT	

M110552

SS 09/03/17 (X4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46122

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

2/3/09/03/23 (41)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

****ensure tension to retract step is 11 to 18 lbs ****

Test fit on aircraft in Eng. lab.

5/09/03/23 (41216)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3454-1	Bushing	B46B35

B46B35

2/3/09/03/18 (41)

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-3	Bushing	40932

40932

2/3/09/03/18 (41)

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3454-5	Bushing	B46933

B46933

2/3/09/03/18 (41)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46122

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total: ~~24~~ 0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

8-4

D3455-1

Spacer

B46133

809/03/18 x4

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3455-3

Spacer

B30227

809/03/18 x4

23.0

D3462042

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3462-042

Bracket ass'y

45060

809/03/18 x4

24.0

AN3104

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN310-4

Nut

M111660

809/03/18 x4

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

AN310-5

Nut

M110552

809/03/18 x4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number: 46122

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN3C5A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

3

AN3-C5A

Bolt

M16985

SS09/03/18 (x4)

27.0

AN44C12

eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN44-C12

Eyebolt

M110342

SS09/03/18 (x4)

28.0

AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN4C15

BOLT

M16155

SS09/03/18 (x4)

29.0

AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN5C11

BOLT

M103248

SS09/03/18 (x4)

30.0

AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN5C15

BOLT

M16155

SS09/03/18 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 46122

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total : 28.0000 EACH(s)

Pick:

Qty Part Number Description Batch
7 AN960C10 Washer

M109148

32.0

AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 AN960C516 Washer

M162842

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch
3 MS21043-3 Nut

M110562

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS24665-227 COTTER PIN

M109174

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch
2 MS24665-229 COTTER PIN

M109174

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: PILOT/CO-PILOT STEP, RH (FOLDING)

Job Number: 46122

Part Number: D412630032

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

NAS1515H5

Washer

MB9430

09/03/17

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/03/23

424

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-032

Location:

PPP Rev:

09/03/23

SP

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24

Job Completion



MF
09-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

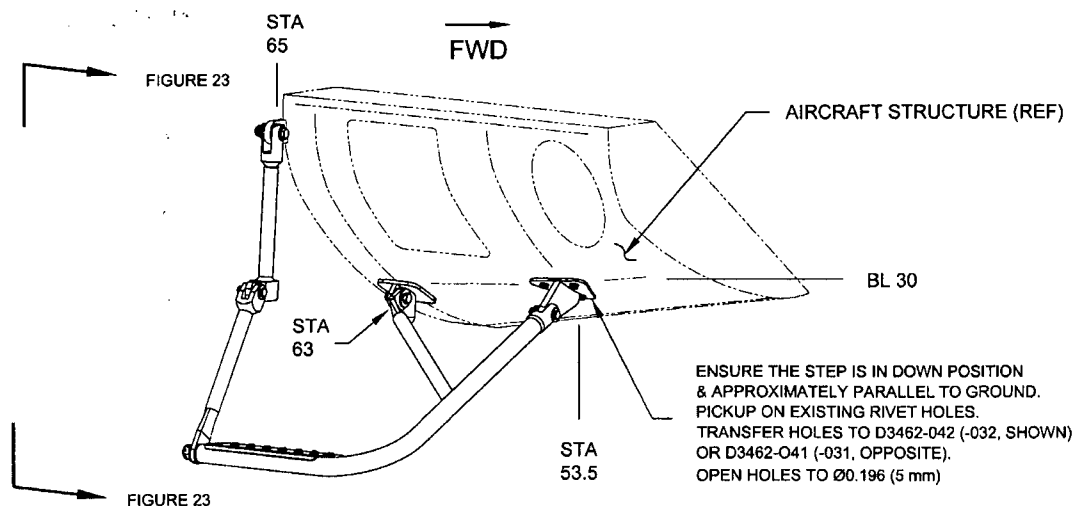
D412-630-031/-032 Pilot/Co-Pilot Folding-Step Installation

FIGURE 21 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown), D412-630-031 LH (Opposite)

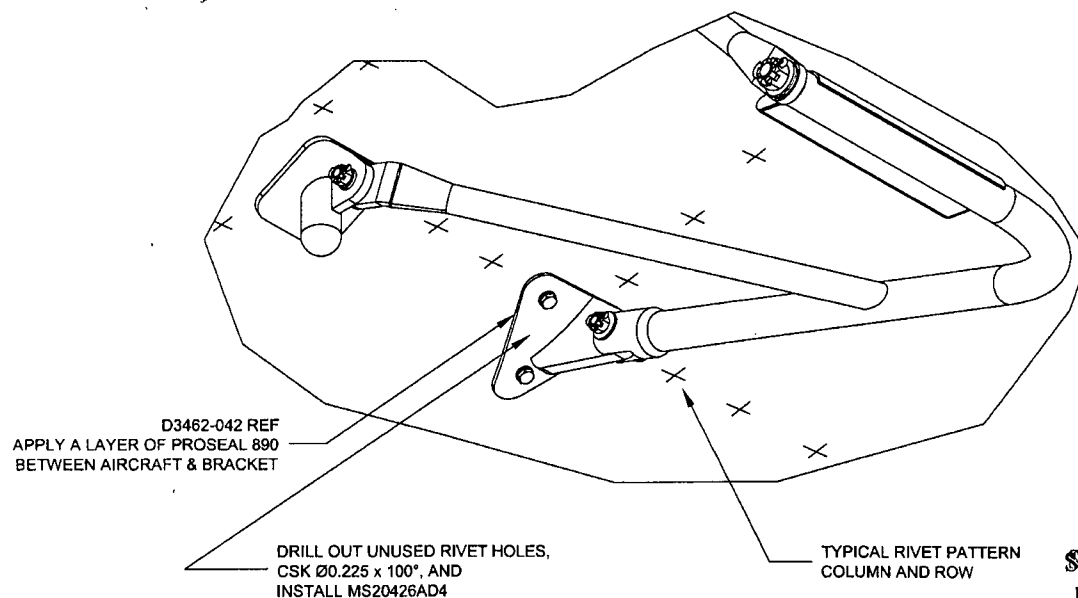


FIGURE 22 – Detail View D3462-042 Bracket Assembly (-032 Installation, Shown) D3462-041, (-031 Installation Opposite)

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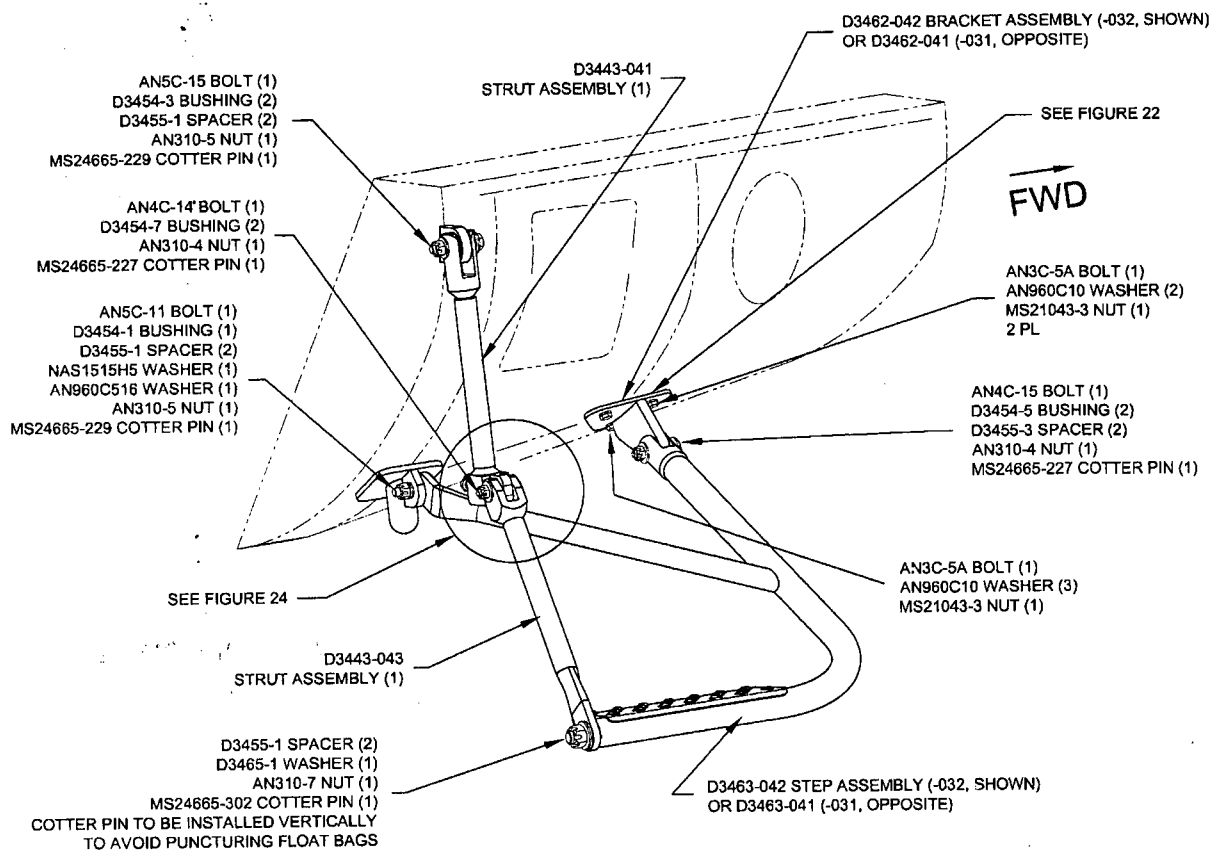


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

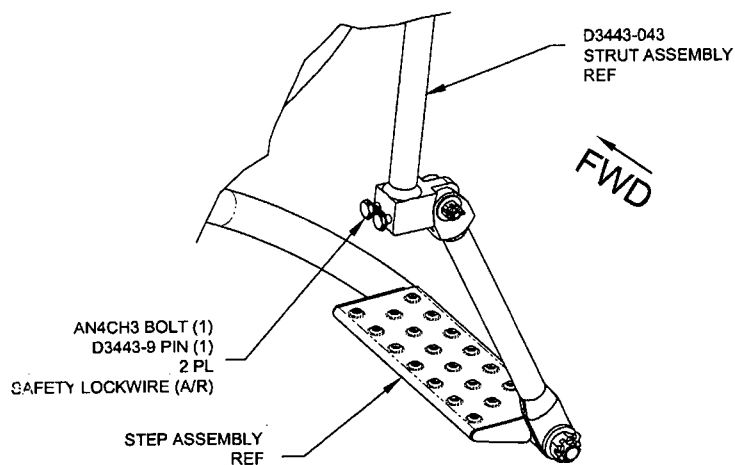


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

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